

Application Serial No.: 10/533,939
Amdt. Dated: February 20, 2009
Reply to Final Office Action of August 21, 2008

LISTING OF CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

1. (Currently Amended) An injection A mold for injection molding manufacturing holders, comprising at least a first and a second mold half moveable relative to each other in a first direction of movement, ~~and a mold cavity~~ and an injection inlet opening for injecting a substantially liquid plastic into the mold cavity, the mold cavity being substantially defined by a female part and a matching male part, while at least the female part and/or the male part is arranged so as to be moveable such that, within the mold, the male part and/or the female part can be brought into a first position wherein between a forward end, facing, in a first direction of movement, towards the mold cavity, and an opposite bottom part of the female part, there is a relatively large, first distance, and a second position wherein between said forward end and said bottom part there is a relatively small second distance, wherein ~~the male part and the first mold half define a first pressure chamber~~ is defined between the male part and the first mold half or between and/or the female part and the second mold half define a second pressure chamber, the pressure chamber containing a pressure medium therein for urging the male part and the female part from the first position into the second position.

2. (Currently Amended) A mold according to claim 1, wherein said injection at least ~~one~~ inlet opening is provided in or near a space between said forward end of the male part and said bottom part of the female part.

3. (Original) A mold according to claim 2, wherein said inlet opening is provided in the male part.

4. (Previously Presented) A mold according to claim 1, wherein the male part is frustoconical and the female part has a corresponding shape, such that with the male and female part in the second position, between the two parts, there is a virtually constant distance.

5. (Previously Presented) A mold according to claim 1, wherein the male part is truncate block-shaped and the female part has a corresponding shape, such that with the male and female part in the second position, between the two parts, there is a virtually constant distance.

6. (Previously Presented) A mold according to claim 1, wherein at least the male part or the female part is biased in the second position.

7. (Previously Presented) A mold according to claim 1, wherein a pressure member is provided for actively keeping the male part and/or the female part in the first position, which pressure member is retractable for having the male and female part move from the first position to the second position.

8. (Original) A mold according to claim 7, wherein the pressure member extends around at least a part of the male part and, with the mold closed, can force, at least hold, the female part in the first position.

9. (Original) A mold according to claim 8, wherein the pressure member is designed as stripper ring.

10. (Previously Presented) A mold according to claim 1, wherein at least one moving male and/or female part is forced into the first position by spring means.

11. (Original) A mold according to claim 10, wherein the spring means are designed such that the respective male or female part can be pushed away to the first position by plastic flowing into the mold cavity, and, when the injection pressure of the plastic falls, is forced to the second position by the spring means.

12. (Previously Presented) A mold according to claim 1, wherein the male and/or the female part is arranged for movement to a product forming position after the mold has been closed.

13. (Previously Presented) A mold according to claim 1, wherein the mold is of multi cavity design, while for each mold cavity at least one moveable part is provided.

14. (Canceled)

15. (Canceled)

16. (Canceled)

17. (Previously Presented) A mold according to claim 10, wherein the spring means are gas-filled means.

18. (New) An injection mold for injection molding plastic holders, the mold comprising:

a first mold half including a male part;

a second mold half moveable relative to said first mold half;

a female part movable within said second mold half, said female part and said male part of said first mold half defining a mold cavity therebetween, and said female part and said second mold half defining a pressure chamber therebetween;

a pressure medium contained within said pressure chamber for urging said female part toward said male part thereby reducing the volume of said mold cavity; and
an injection inlet opening for injecting a substantially liquid plastic into said mold cavity.

19. (New) An injection mold as defined in Claim 18, wherein said male part and said female part are movable between a first position, wherein said mold cavity has a first volume, and a second position, wherein said mold cavity has a second volume, said first volume being greater than said second volume, and wherein said pressure medium urges said female part into said second position.

20. (New) An injection mold as defined in Claim 19, wherein said first mold half includes a movable pressure member, said pressure member extending from said first mold half to engage said female part upon closure of the mold for urging said female part into said first position, and said pressure member retracting as said pressure medium urges said female part into said second position.

21. (New) An injection mold as defined in Claim 20, wherein said pressure member is a stripper ring surrounding said male part of said first mold half.

22. (New) An injection mold for injection molding plastic holders, the mold comprising:
a first mold half;
a second mold half moveable relative to said first mold half;
a male part movable within said first mold half, said male part and said second mold half defining a mold cavity therebetween, and said male part and said first mold half defining a pressure chamber therebetween;
a pressure medium contained within said pressure chamber for urging said male part toward said second mold half thereby reducing the volume of said mold cavity; and

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an injection inlet opening for injecting a substantially liquid plastic into said mold cavity.

23. (New) An injection mold as defined in Claim 22, wherein said male part is movable between a first position, wherein said mold cavity has a first volume, and a second position, wherein said mold cavity has a second volume, said first volume being greater than said second volume, and wherein said pressure medium urges said male part into said second position.

24. (New) An injection mold as defined in Claim 19, wherein said second mold half includes a movable pressure member, said pressure member extending from said second mold half to engage said male part upon closure of the mold for urging said male part into said first position, and said pressure member retracting as said pressure medium urges said male part into said second position.

25. (New) An injection mold as defined in Claim 24, wherein said pressure member is a stripper ring surrounding said male part.